## ABSTRACT

An object of the invention is to provide a hard sintered body indexable insert in which a hard sintered body used as a cutting edge is brazed to all corners of a tool substrate and to seating grooves of the upper and lower surfaces thereof, and which has high performance and is low-cost. A brazing alloy a part of which contains 0.5 to 65 wt % Ti and/or Zr and the remainder of Cu and inevitable impurities is used as a typical brazing alloy, and the hard sintered body is brazed to the tool substrate by heating it in a vacuum or in an inert gas atmosphere. The thickness of the tool substrate between the upper and lower seating grooves is 30% to 90% of the entire thickness of the hard sintered body indexable insert, and the cutting-edge length of the hard sintered body is 0.5 mm to 4 mm.